

Work Order ID 62075

Wednesday, September 15, 2010 3:15:41 PM



Page 1

Item ID: D2804-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 9/15/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-9-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2804	Rev C

100 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-1 Into arm as per Dwg D2804

EP 10/12/16 *(Signature)*

110 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Swirl 16

(X4)

24

120 0.00



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Powdercoat

Memo

0.00

Powder Coating

START TIME:

3:00 FINISH TIME:

OVEN TEMPERATURE:

9:00

H. 10/12/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10/12/12

4 0

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Press D2809 into arm as per Dwg D2804

9/10/12/20 (4)

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 □2-Assemble as per Dwg D2804.

9/10/12/20 (4)

W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Bracket Assembly

Start Date: 9/15/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/12/20

(+9)

-041

Quality Control

170

Identify as per dwg & Stock Location 150

0.00



Packaging

Memo

0.00

10/12/20

sl (+9)

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/12/21

MF
10-12-21

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, September 15, 2010 3:15:47 PM

Page 1

Work Order ID: 62075

Parent Item: D2804-041

Parent Item Name: Bracket Assembly





Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D2804-1  Bracket		Manufactured	No			100	Each	0.0000	1	4		9/30/12/16	
D2805-1  Stop		Manufactured	No			100	Each	10.0000	1	4		9/30/12/16	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST024		10							
				58527		10							
NAS1515H3  Washer		Purchased	No			100	Each	34.0000	4	16		9/30/12/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST277		34							
				111268		34							
AN3C16A  Bolt		Purchased	No			150	Each	59.0000	2	8		9/30/12/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		59							
				111193		9							
				111425		50							

B62468 (4X)

4
16
9/30/12/20
M115675 (16X)

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, September 15, 2010 3:15:47 PM

Page 2

Work Order ID: 62075

Parent Item: D2804-041

Parent Item Name: Bracket Assembly

Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 4.00

Required Qty: 4.00

D2809

Manufactured No

150

Each

43.0000

1



Bushing



4
EP 9/10/12/20

Location

Loc Qty

Loc Code

ST025

43

34035

12

46438

1

47733

30

MS21043-3

Purchased No

150

Each

2,643.000

2



Nut



8
EP 9/10/12/20

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2567

109147

4

111383

46

112314

2517

8

Wednesday, September 15, 2010 3:15:47 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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SHOP COPY

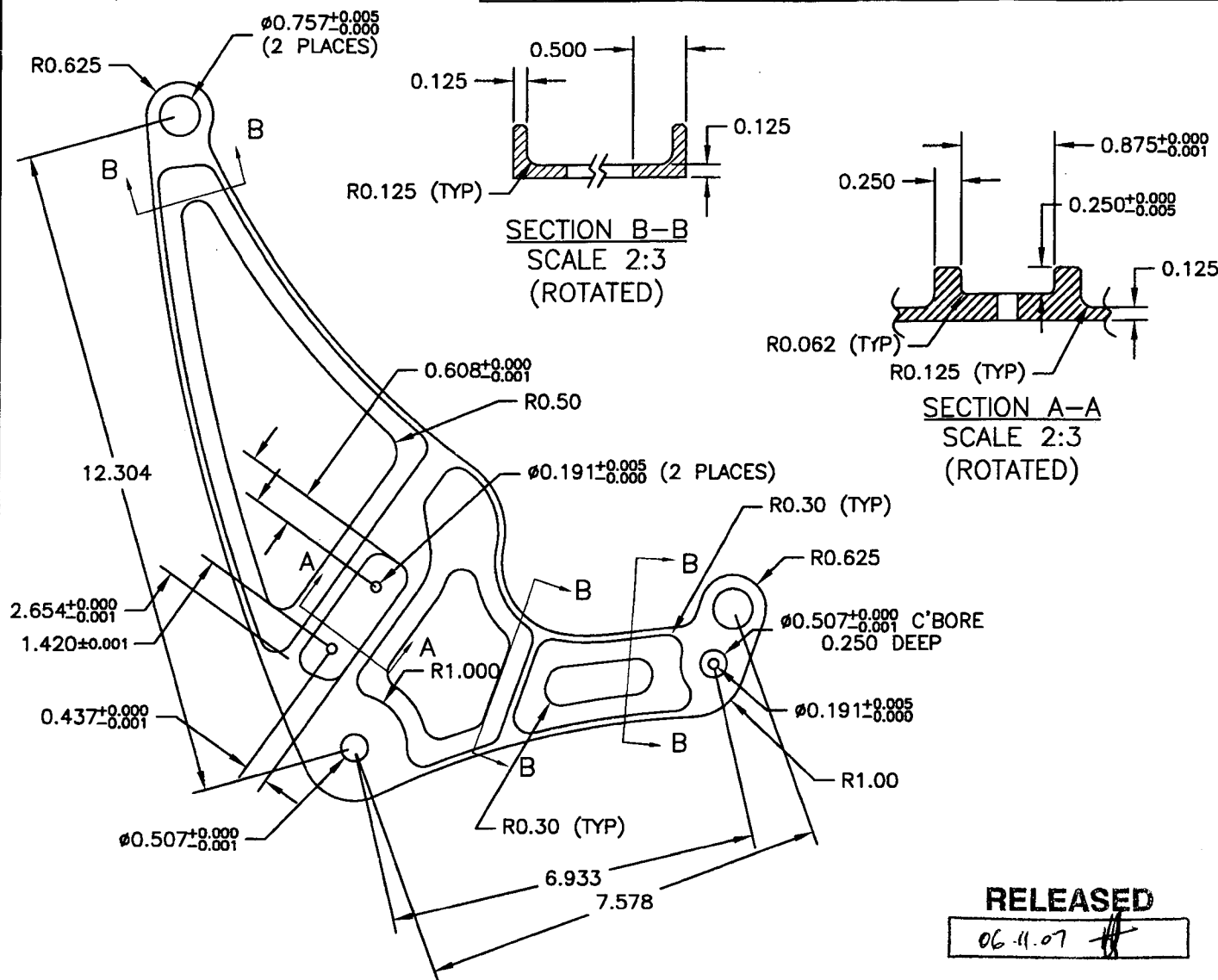
RE
ENG

DART

UNCONTROLLED
SUBJECT TO AMENDMENT

WORK ORDER
NO. 42075
13810-914

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE	06.10.16		TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07		NEW ISSUE		
B	04.11.22		ADD CUTOUTS & -043/-044		
C	06.10.16		CHANGE GEOM. TO ADD CLEARANCE		



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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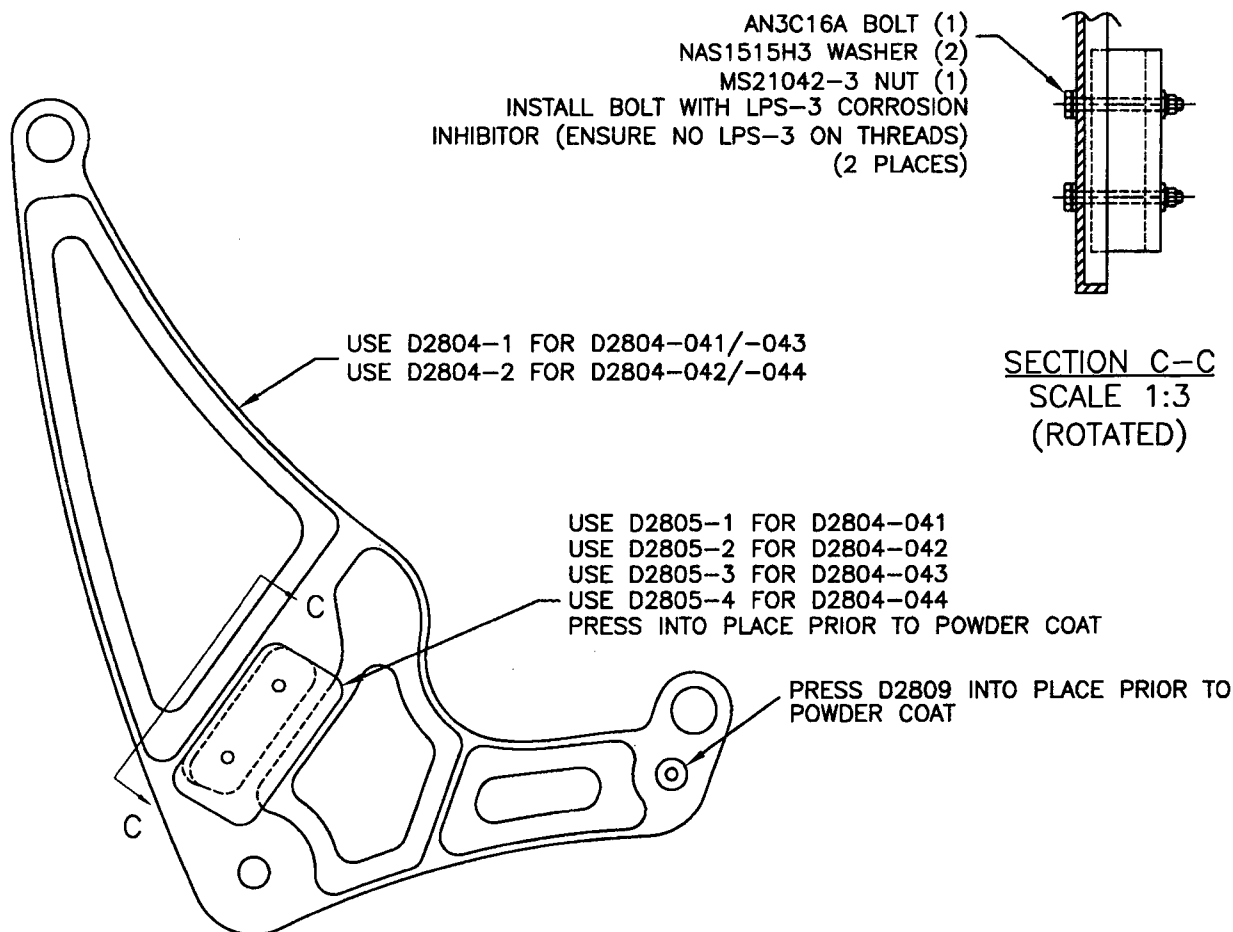
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

w/o 42076



RELEASED

06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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